

Work Order ID 76216

76216

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November-07-11 2:38:21 PM

Item ID: D3204-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Release Pedal Assembly
 Start Date: 07/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/08 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3204	Rev A1								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. 2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. 3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured.								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

EL 12-1-23 (X5)

5 Ø RE2-01-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>W</u>	<u>12</u>	<u>01</u>	<u>24</u> (5)
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>5</u>	<u>12</u>	<u>01</u>	<u>24</u>
140 *140* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo ***Cover holes for bushing*** START TIME: <u>1-30</u> OVEN TEMPERATURE: <u>320 OF</u> FINISH TIME: <u>2-00</u>	0.00 0.00							

W118489

5x0 M-12/01/25

5 & 12/01/23
counted

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 76216***76216***

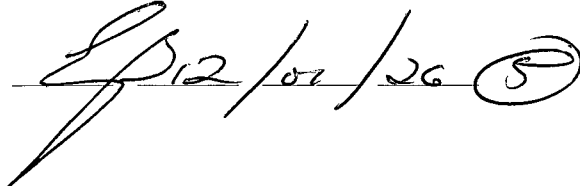
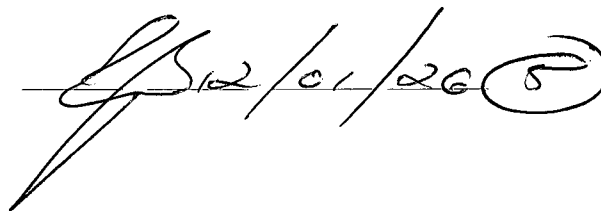

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
160 *160* Small Fab Small Fab	Small Fab Memo Install D3204-7 bushing as shown in Dwg D3204	0.00 0.00							
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							 <u>5</u>

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
180									
Packaging	Memo	0.00	SN	1260126		5			
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/11/26 *[Signature]*
 12-01-26
 6

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 76216

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Parent Item: D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1 *D3204-1* Tube		Manufactured	No			100	Each	8.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				8					
				71607				8					
D3204-11 *D3204-11* Plate		Manufactured	No			100	Each	24.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST45				14					
				57522				14					
				WA019				10					
				55463				10					
D3204-13 *D3204-13* Gusset		Manufactured	No			100	Each	46.0000	2	8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				46					
				70315				3					
				73465				43					
D3204-3 *D3204-3* Arm		Manufactured	No			100	Each	5.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				5					
				65139				1					
				73464				4					

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Q 12-1-23

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Q 12-1-23

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Q 12-1-23

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Q 12-1-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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76216

Parent Item: D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 4.00

Required Qty: 4.00

D3204-5

Manufactured No

100

Each

8.0000

1 4

D3204-5

Arm

**

EL 12-1-23

Location

Loc Qty

Loc Code

WA

8

71608

8

D3204-9

Manufactured No

100

Each

5.0000

1 4

D3204-9

Pedal

**

EL 12-1-23

Location

Loc Qty

Loc Code

WA

5

68573

5

D3204-7

Manufactured No

160

Each

9.0000

2 8

D3204-7

Bushing

**

EP 12/01/26

Location

Loc Qty

Loc Code

GA

9

70323

9

9

B77091 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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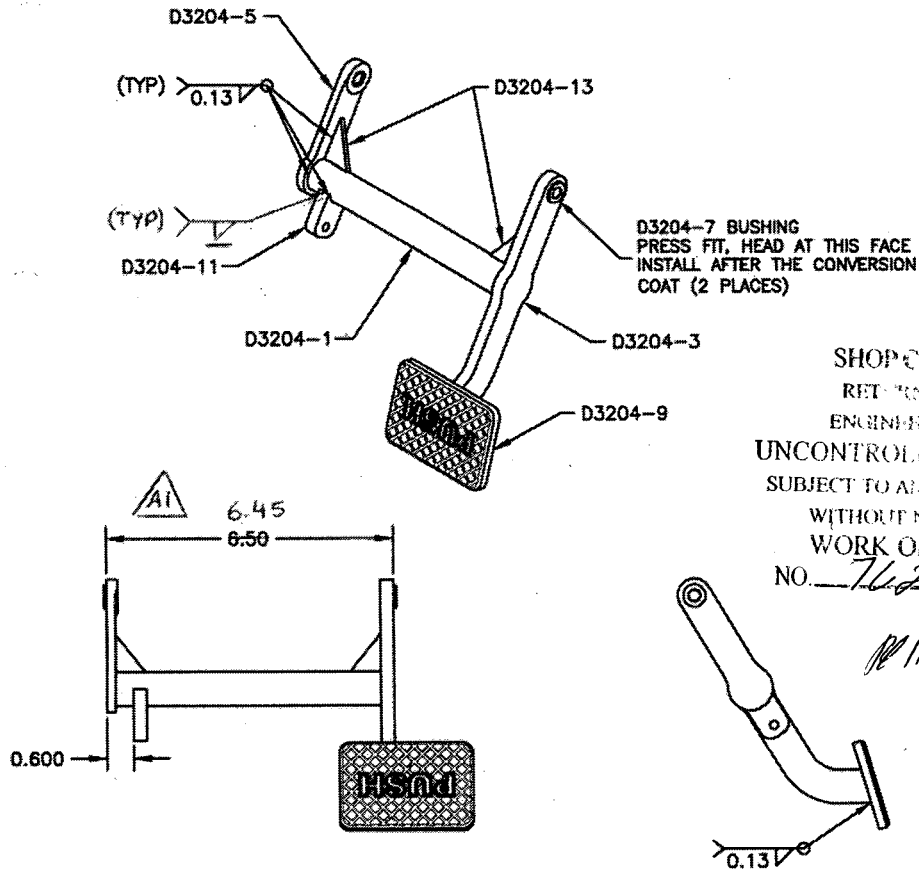
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76214

11-08

D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

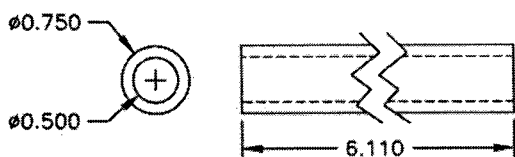
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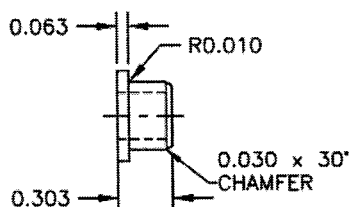


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

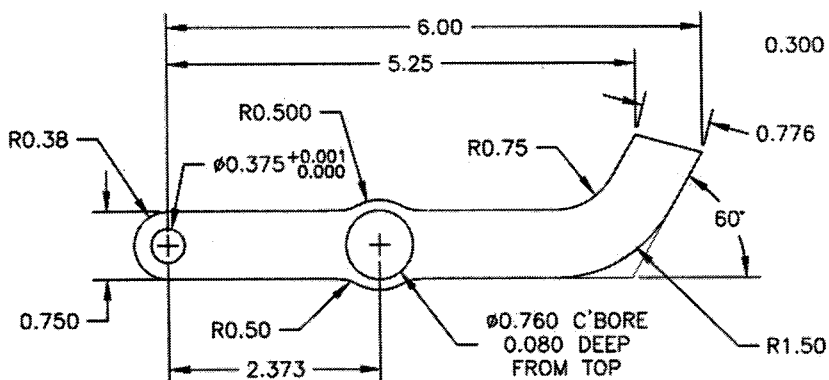
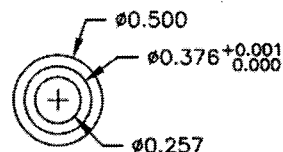
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04.04.05



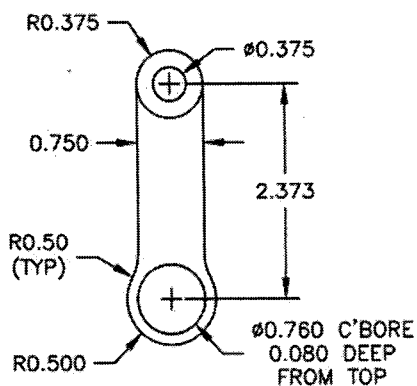
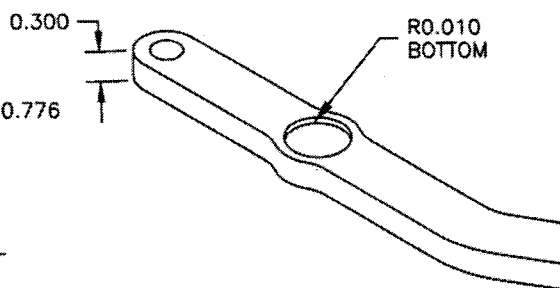
2 D3204-1 TUBE
SCALE 1:2



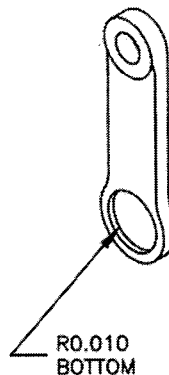
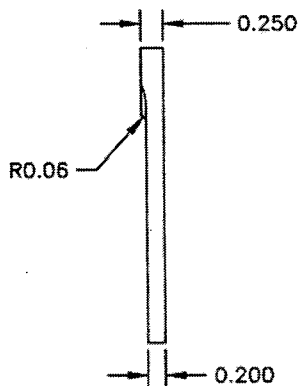
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SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



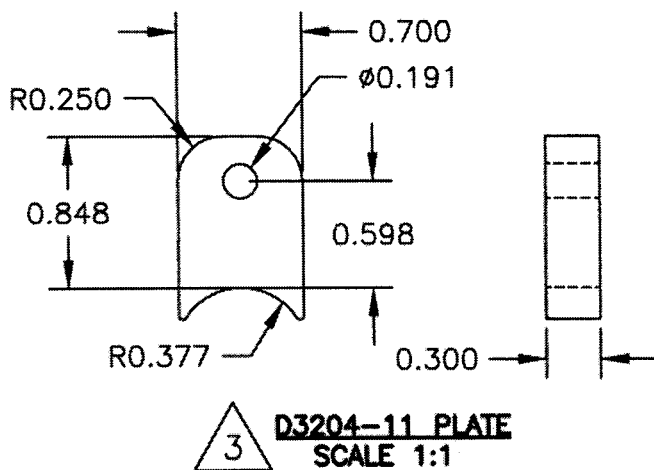
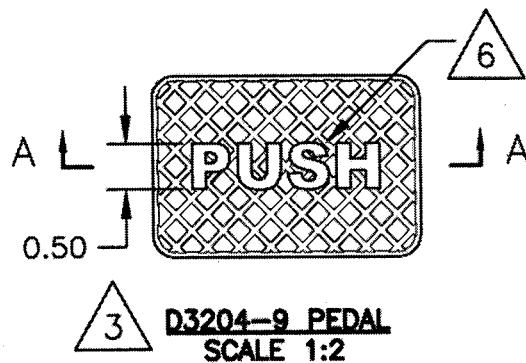
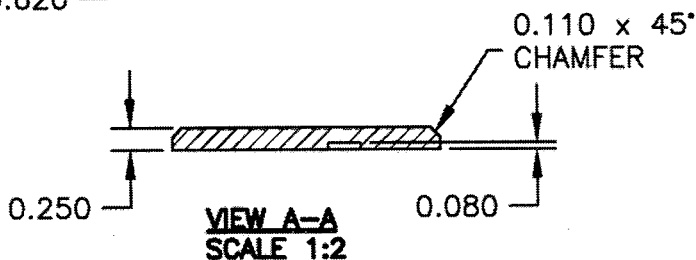
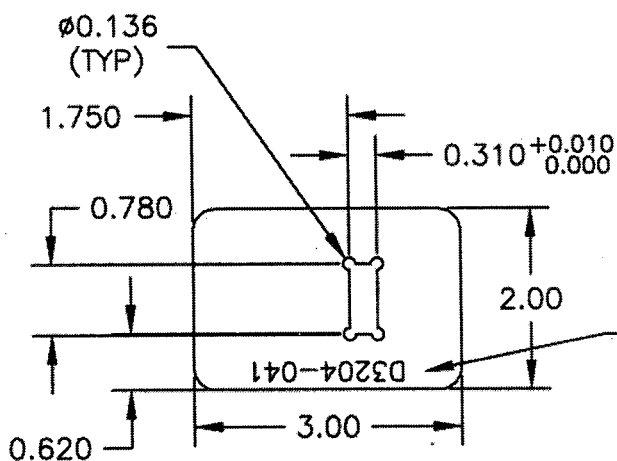
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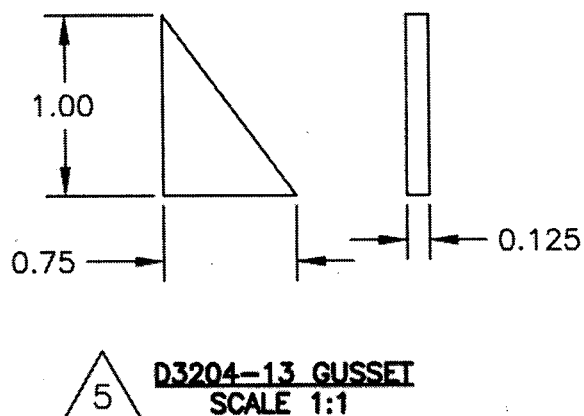
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

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D3204-11 PLATE
SCALE 1:1

76216



D3204-13 GUSSET
SCALE 1:1

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